



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3690-1
Job Sheet 168983



Part No: D3690-1

Job Qty: 2 ea

Part Name: Glareshield



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/28/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP Rev A New Issue 08/04/28 DL verified by:DD IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec IPP Rev:C 08-10-07 revC as per dwg DD verified by:EC lpp Rev. D Add Step 115 Dry Material 10/04/21 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	2 pcs		12/22/17	0.00	0.00	Purchasing		AC 18/02/05
140	Packaging	2 pcs		12/22/17	0.00	0.00	Packaging2		AC 18/02/05
150	QC	2 pcs		12/22/17	0.00	0.00	QC6		
170	Packaging	2 pcs		12/22/17	0.00	0.00	Packaging3		
180	QC21-SA	2 Ea		12/22/17	0.00	0.00	QC21		

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

P0 038509

NOV 29 2017

ACB

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	D3690-1P	2	0	0	0
	MLEXS.093-F6006-02	53	474	0	0

Part Specifications

Specifications could not be found.

Plex 11/28/17 12:58 PM dart.poulin.mario

SCRAP

P.T.O.

DART
AEROSPACE
S039104



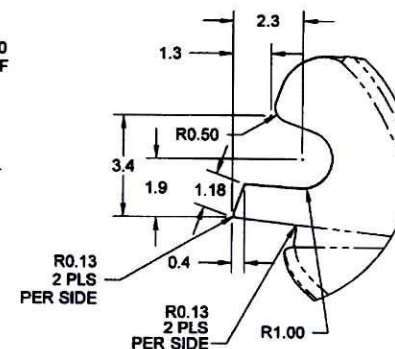
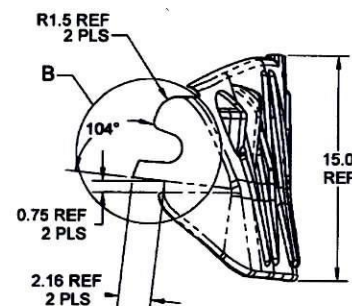
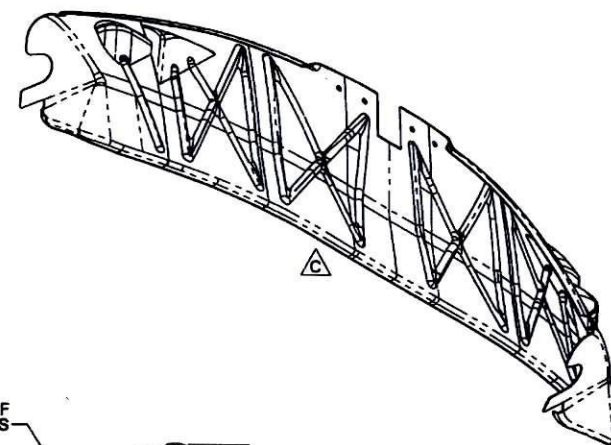
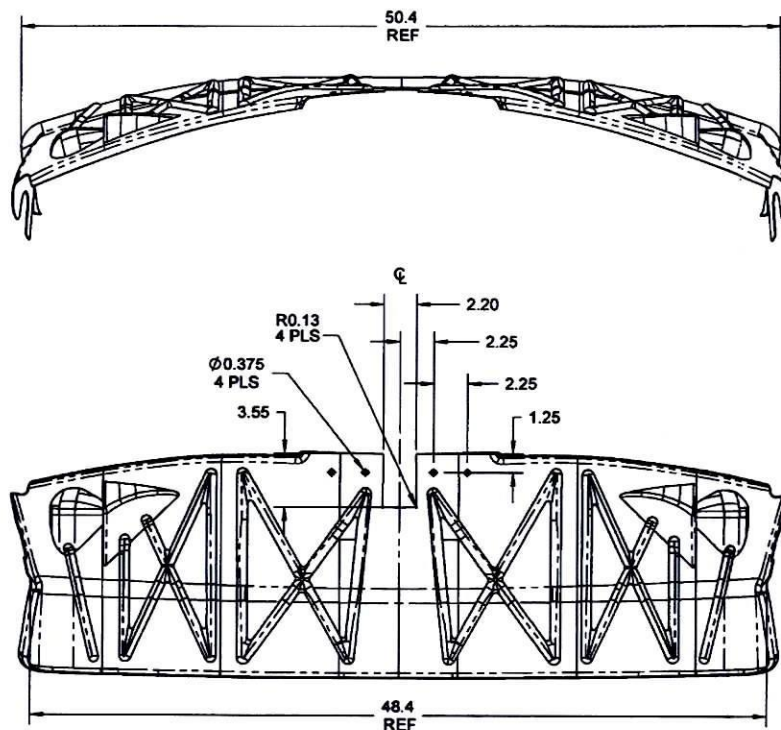
Glareshield

PART NO: D3690 – 1
Original Serial #: S039104
Revision:
Operation: Purchasing
Change No:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 02/05/18 Job No: 168983
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D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED
03-04-11

DETAIL B
SCALE 2X

THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038509

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-436-0004
Fax: 416-736-0010

PO No: PO038509
PO Date: 11/29/17
Due Date: 12/18/17
**Purchase Order
Revision:**
Revision Date:

E-MAILED
DEC 05 2017

Ship-To Contact: Baker, Diane Phone:
dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3690- 1P			Glareshield As Per Dwg D3690 Rev. C	Firmed	12/18/17	2 pcs	0 pcs 2x	2 pcs	\$220.00/pcs	\$440.00 AT 12/02/05

Line Item Note job# 168983

Grand Total: \$440.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

CL
QUB

Plex 12/5/17 10:32 AM dart.baker.diane

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 38509 SO # 021409

Part #	<u>D-3690-1P</u>	Qty.	<u>2</u>	Batch #	<u>- 001</u>
Description	<u>GLARESHIELD ASSEMBLY</u>	Material usage	<u>5 SHEETS</u>	Lot#	<u>M127208</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: 
(Approved QA Signatory)

Date: JAN. 30, 2018 C O F C # 034

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☒</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : <u>18-02-06</u>		Step #: <u>150</u>		QTY Effective : <u>82</u>			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				<u>PD 18-02-08</u>																	
Found at inspection that glove shield had extra holes on each side of top portion See drawing for location. QC cad file that was sent to the supplier was incorrect. No fault on supplier				Scrap destroy Correct cad file one to be sent to supplier in order to replace the scrap one. See attach Email				Completed By																	
								<u>PD 18-02-08</u>																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
								<u>PD 18-02-08</u>																	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☒	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	☒ Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER : _____							

Patrick Duval

From: Robert Aboud
Sent: Wednesday, February 07, 2018 3:24 PM
To: Chris Provencal; Linda Lacelle; Patrick Duval
Cc: Jean-Luc Menard; David Shepherd
Subject: RE: Shipping date / DART1387 / Helicentro

It worked, they've got it

Rob Aboud

Director of Supply Chain
DART AEROSPACE
T 1-613-632-5200 Ext.244
M 1-514-979-6138
www.dartaerospace.com



From: Chris Provencal
Sent: Wednesday, February 07, 2018 3:16 PM
To: Robert Aboud <raboud@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro

Robert,

I've used your link to a shared link for the necessary file:

<https://drive.google.com/open?id=1Or4gugHK0H86E6j7ZFFEIbjyNjvUOdj1>

Chris

From: Robert Aboud
Sent: Wednesday, February 07, 2018 3:05 PM
To: Chris Provencal <cprovencal@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro

Ok I've asked Plastech to start reforming qty 3 and to provide a completion date ASAP

Rob Aboud

Director of Supply Chain
DART AEROSPACE
T 1-613-632-5200 Ext.244
M 1-514-979-6138
www.dartaerospace.com



From: Chris Provencal

Sent: Wednesday, February 07, 2018 2:55 PM

To: Linda Lacelle <llacelle@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Patrick Duval <pduval@dartaero.com>

Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: RE: Shipping date / DART1387 / Helicentro

Robert,

I've corrected the CAD file in the vault and removed the holes that shouldn't be there (/3D Data/D3600 Series/D3690/Outsource Data). To summarize the change: the D3690-1 Glareshield should have no holes except for the qty(4) 0.375" holes shown on sheet 3 of D3690 Rev. C.

The file is too large to attach to an email (53MB), we need to get that file to Plastec for use with all future Glareshields. We might have to FedEx a USB drive or use a file sharing service.

Chris

From: Linda Lacelle

Sent: Wednesday, February 07, 2018 2:49 PM

To: Robert Aboud <raboud@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>

Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: RE: Shipping date / DART1387 / Helicentro

Thx Rob, these would need to be in early next week

From: Robert Aboud

Sent: Wednesday, February 7, 2018 2:48 PM

To: Linda Lacelle <llacelle@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>

Cc: Jean-Luc Menard <jmenard@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Subject: RE: Shipping date / DART1387 / Helicentro

Checking with Plastech if they have material to rerun quickly

Rob Aboud

Director of Supply Chain

DART AEROSPACE

T 1-613-632-5200 Ext.244

M 1-514-979-6138

www.dartaerospace.com



From: Linda Lacelle
Sent: Wednesday, February 07, 2018 1:41 PM
To: Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; Robert Aboud <raboud@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro
Importance: High

This is going to cause a HUGE problem for the customers! They have already been pushed out twice! I am sure Plas-Tech will not be able to ship more next week, which would be a THIRD time pushing out the dates on the customers! Can we not at least push 3 through?? I am sure we will loose these orders, as well as piss off the customers!

L

From: Chris Provencal
Sent: Wednesday, February 7, 2018 1:36 PM
To: Linda Lacelle <llacelle@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: RE: Shipping date / DART1387 / Helicentro

Linda,

The CAD file we provided the supplier was incorrect and shows holes that are meant to be drilled by the customer upon install. This was an error by engineering.

The presence of these holes may cause a compatibility issue for the customer and I recommend we scrap the parts. I've deleted the CAD file in the vault and will create a new CAD file to send to the customer. I want to confirm some information with Pat before releasing the new file.

Chris

From: Linda Lacelle
Sent: Wednesday, February 07, 2018 12:12 PM
To: Chris Provencal <cprovencal@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: FW: Shipping date / DART1387 / Helicentro
Importance: High

D3690 Glare shields – have we decided if these are acceptable or not?? I need to let the customers know if they are going to be late

L

From: Oscar Martinez
Sent: Wednesday, February 7, 2018 12:10 PM
To: Linda Lacelle <llacelle@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>
Subject: Shipping date / DART1387 / Helicentro

Hi team,

Could you please let me know if we are still on time to ship order DART1387. Promise ship date was for this week. Could you please confirm and provide ship date?